

Work Order ID 59664

Wednesday, June 09, 2010 11:40:26 AM



Page 1

Item ID:	D3780-041	Accept		Setup	Start		
Revision ID:				Stop			
Item Name:	Armrest Assembly						
Start Date:	6/9/2010	Start Qty: 4.00		Cust Item ID:			
Required Date:	7/2/2010	Req'd Qty: 4.00		Customer:			
Reference:							
Approvals:	Process Plan: <u>H</u>	Date: <u>106-09</u>	Tooling:	Date:	Run	Start	
	QC: _____	Date: _____	SPC (Y/N):	Date: _____	Stop		

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
100		0.00							
	Small Fab								
Small Fab	Memo	0.00							
Small Fab	1- assemble as per dwg D3780 ****torque screws as per dwg D3780****								
110	QC5- Inspect part completeness to step on W/O	0.00	<u>8/10/09/27</u>						
	Memo	0.00							
QC									
Quality Control									
120	Identify as per dwg & Stock Location: <u>261</u>	0.00							
	Memo	0.00							
Packaging									
Packaging									

EBro 109/27 (3)

8/10/09/27 (3)

8/10/09/28 (3)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Item ID: D3780-041

Accept



Setup Start



Revision ID:

Item Name: Armrest Assembly

Stop



Start Date: 6/9/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 7/2/2010 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center ID

130



QC

Quality Control

Operation
Description

QC21- Final Inspection - Work Order Release

Set Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

0.00

Memo

0.00

10/09/28 JJ

BA 10-9-28
(3)

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Picklist Print

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Page 1

Work Order ID: 59664



Parent Item: D3780-041



Parent Item Name: Armrest Assembly

Start Date: 6/9/2010

Required Date: 7/2/2010

Comments: IPP Rev:A 08-05-26 new issue DD verified by:ec
IPP Rev:B 08-07-22 revB as per dwg verified by:EC
IPP Rev:C 09-01-08 rev.C as per dwg DD verified by:ec

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/	Replacement	Mfg/ Manufactured	Bin No	Primary	Last	Route 100	Unit of Each	Qty on 8.0000	Qty per Kit 1	Total 4	Qty	Date	Status
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Arm Assembly



SB 10/09/24

Location	Loc Qty	Loc Code
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ST205	2	
44542	2	
ST255	6	
56900	2	
58010	4	

D3781-041



Lateral Cushion Assembly

Manufactured	No	100	Each	1.0000	1	4
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SB 09/09/27

Location	Loc Qty	Loc Code
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ST185	1	
47992	1	

D3781-043



Armrest Cushion Assembly

Manufactured	No	100	Each	4.0000	1	4
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BG1788 (3x)

SB 10/09/24

Location	Loc Qty	Loc Code
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ST185	4	
48436	1	
56902	3	

D3785-3



Bracket

Manufactured	No	100	Each	6.0000	1	4
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SB 10/09/24

Location	Loc Qty	Loc Code
----------	---------	----------

ST088	6	
56903	6	

3

W/O:		WORK ORDER CHANGES					
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Parent Item: D3780-041



Parent Item Name: Armrest Assembly

Start Date: 6/9/2010

Required Date: 7/2/2010

Comments: IPP Rev:A 08-05-26 new issue DD verified by:ec
IPP Rev:B 08-07-22 revB as per dwg verified by:EC
IPP Rev:C 09-01-08 rev.C as per dwg DD verified by:ec

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ D3977-1	Replacement	Mfg/ Manufactured	Bin No	Primary	Last	Route 100	Unit of Each	Qty on 9.0000	Qty per Kit 1	Total 4	Qty	Date	Status
Bolt											SB	10/09/24	
D3978-1											3		
Nut											4		
D3979-1											3		
Washer											4		
AN960JD10L	NAS1149D0332J	Purchased	No								3		
Washer											8		
											SB	10/09/24	
											6		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Parent Item: D3780-041



Parent Item Name: Armrest Assembly

Start Date: 6/9/2010

Required Date: 7/2/2010

Comments: IPP Rev:A 08-05-26 new issue DD verified by:ec
IPP Rev:B 08-07-22 revB as per dwg verified by:EC
IPP Rev:C 09-01-08 rev.C as per dwg DD verified by:ec

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ AN970-6	Replacement	Mfg/ Purchased	Bin No	Primary Last	Route 100	Unit of Each	Qty on 41.0000	Qty per Kit 2	Total 8	Qty	Date	Status
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Washer

Location	Loc Qty	Loc Code
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ST349	41	
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114341	41	
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MS21042L3

Purchased

No



Nut

Location	Loc Qty	Loc Code
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ST300	3346	
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113537	18	
--------	----	--

113644	3	
--------	---	--

114523	825	
--------	-----	--

114718	500	
--------	-----	--

114784	2000	
--------	------	--

MS24665-302

Purchased

No



Cotter Pin

Location	Loc Qty	Loc Code
----------	---------	----------

ST309	62	
-------	----	--

113644	62	
--------	----	--

W/O:		WORK ORDER CHANGES					
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Parent Item: D3780-041



Parent Item Name: Armrest Assembly

Start Date: 6/9/2010

Required Date: 7/2/2010

Comments: IPP Rev:A 08-05-26 new issue DD verified by:ec
IPP Rev:B 08-07-22 revB as per dwg verified by:EC
IPP Rev:C 09-01-08 rev.C as per dwg DD verified by:ec

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ MS24693-C272	Replacement Purchased	Mfg/ Purchased	Bin No	Primary Last	Route 100	Unit of Each	Qty on 1,296.000	Qty per Kit 2	Total 8	Qty	Date 10/09/24	Status
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Screw

Location	Loc Qty	Loc Code
ST310	1296	
17137	477	
17831	519	
9370	300	

MS24693-C277



Screw

Location	Loc Qty	Loc Code
ST310	42	
109297	4	
113644	38	

NAS1149D0663J



Washer

Location	Loc Qty	Loc Code
ST298	156	
113524	4	
114348	152	

M 115698

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

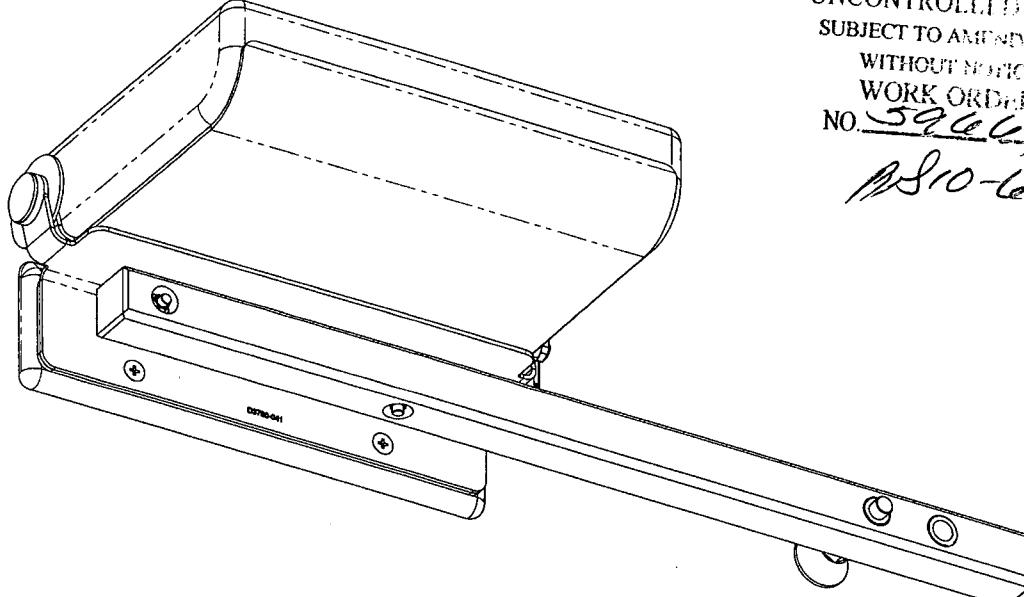
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8 7 6 5 4 3 2 1

ITEM	QTY -041	P/N	DESCRIPTION
1	X	D3780-041	ARMREST ASSEMBLY
3	1	D3696-041	ARM ASSEMBLY
4	1	D3781-041	LATERAL CUSHION ASSEMBLY
5	1	D3781-043	ARMREST CUSHION BASE ASSY
6	1	D3785-3	BRACKET
7	1	D3977-1	BOLT (CARRIAGE), UNC
8	1	D3978-1	NUT (CASTELLATED), UNC
9	1	D3979-1	WASHER (SQUARE HOLE)
12	2	AN960JD10L	WASHER
13	2	AN970-6	WASHER
14	2	MS21042L3	NUT
15	1	MS24665-302	COTTER PIN
16	2	MS24693-C272	SCREW
17	2	MS24693-C277	SCREW
18	1	NAS1149D0663J	WASHER

SHOP COPY
 RETURN TO
 ENGINEERING
 UNCONTROLLED DOCUMENT
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 59664
MS10-6-09



D3780-041 ARMREST ASSEMBLY

RELEASED 09/07/21/144

D	REDESIGNED BASED FEEDBACK FROM END USERS AT HAI 2009	MB	09.05.11
C	UPDATED BOM TO CURRENT STANDARDS; REDESIGNED ITEM 4. REASON: COMPATIBILITY WITH 204 SEATS	MB	08.11.03
B	REDESIGNED TO ELIMINATE FWD/AFT ADJUSTMENT	MB	08.07.17
A	NEW ISSUE	MB	08.04.29
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	<i>[Signature]</i>	DRAWING NO. D3780 REV. D SHEET 1 OF 3	
CHECKED	<i>[Signature]</i>		
MFG. APPR.	<i>[Signature]</i>		
APPROVED	<i>[Signature]</i>		
DE APPR.	<i>[Signature]</i>	TITLE	SCALE
DATE 09.05.11		ARMREST ASSEMBLY NTS	

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8 7 6 5 4 3 2 1

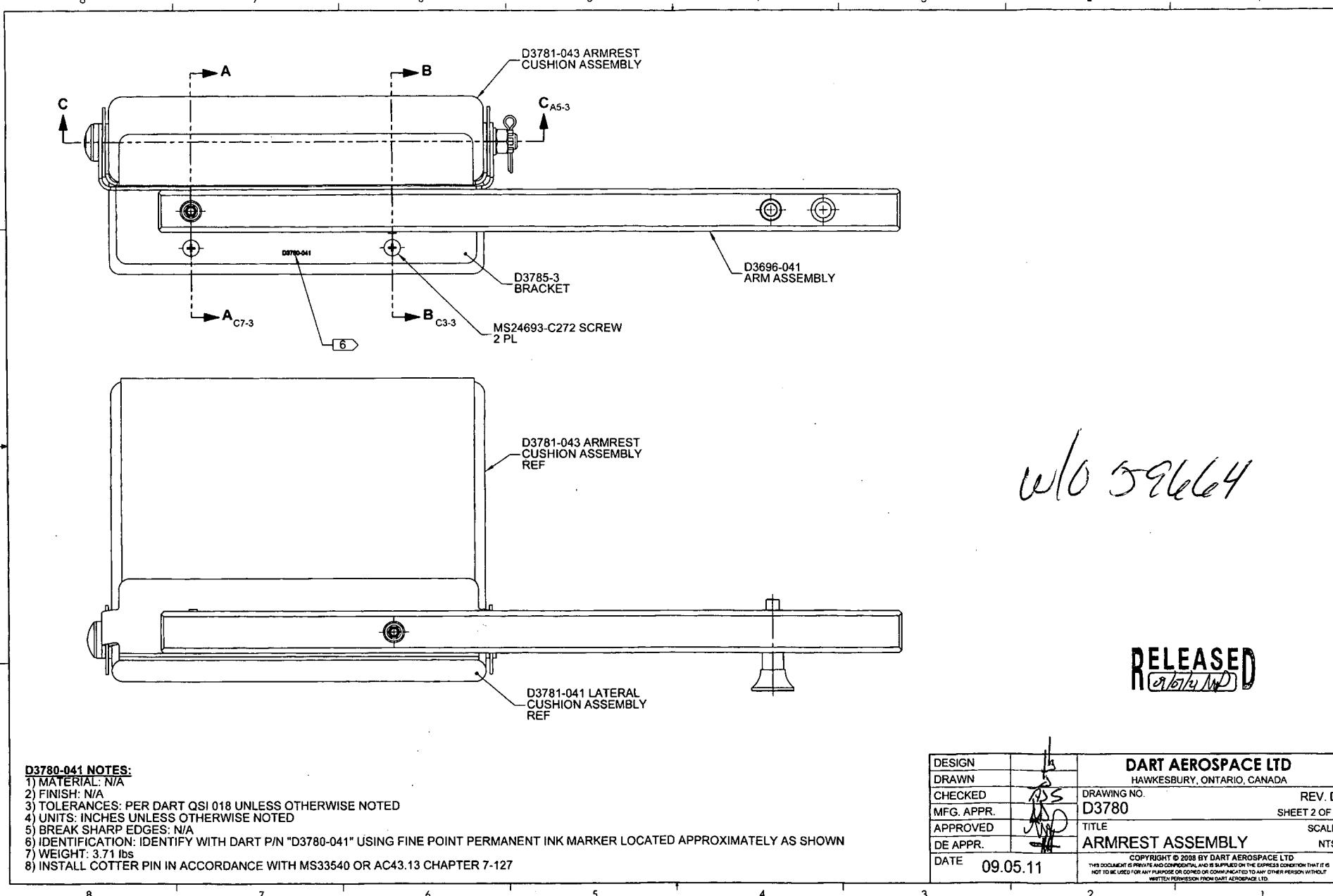
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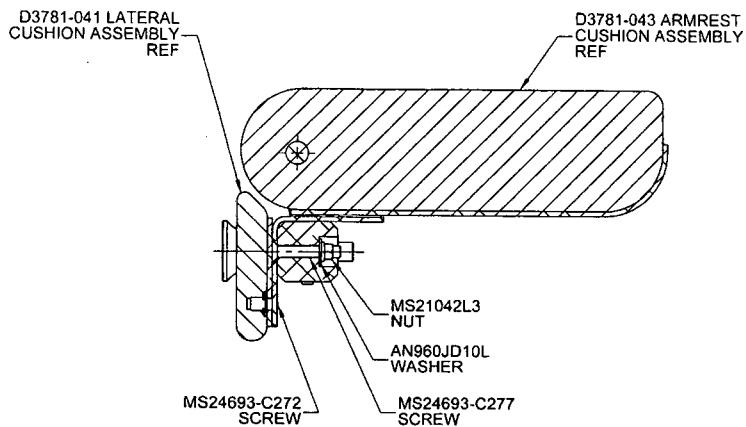


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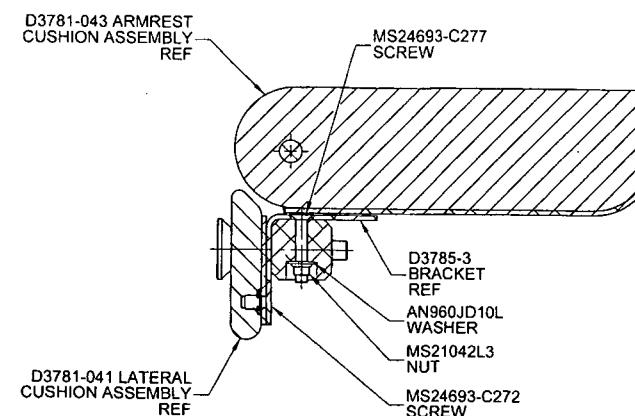
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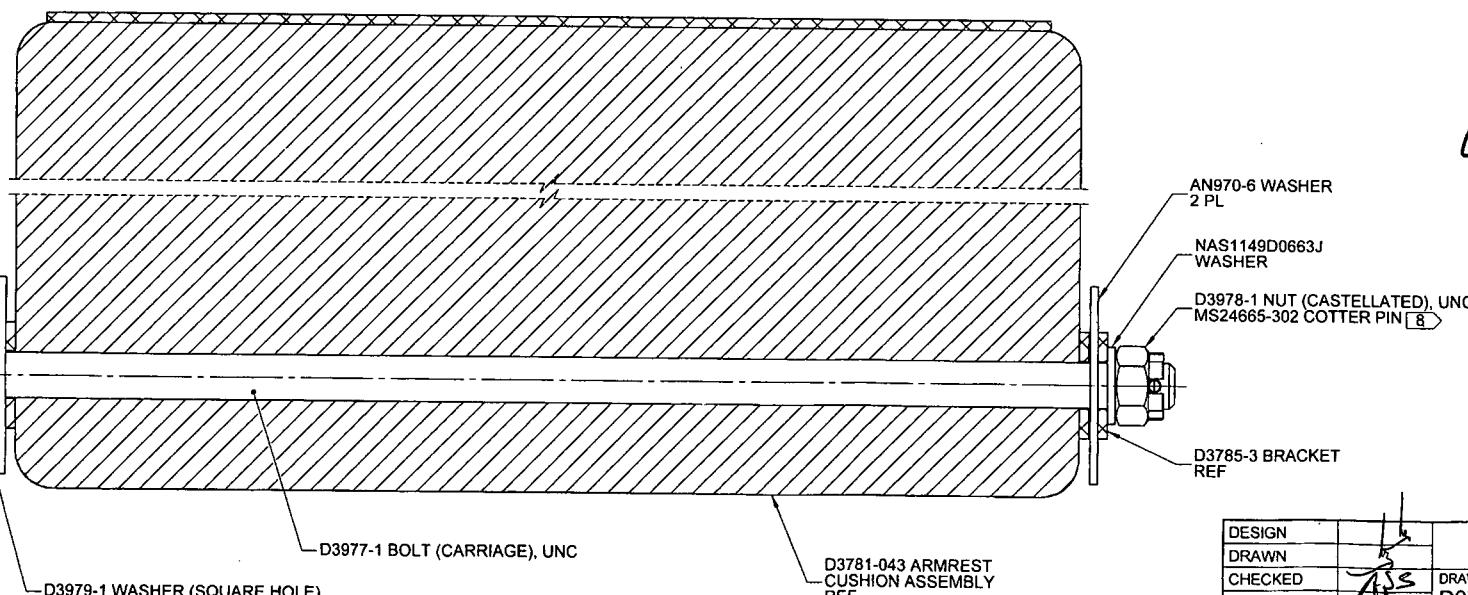
NOTE: Date & initial all entries



SECTION A-A C7-2



SECTION B-B C6-2



SECTION C-C D5-2
SCALE: 2X

DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN		
CHECKED		
MFG. APPR.		
APPROVED		
DE APPR.		
DATE	09.05.11	
DRAWING NO.	D3780	
REV. D	SHEET 3 OF 3	

TJS

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07/14/11

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